DURINOX 303

Electrodes MMA [SMAW]

Special application - steel welding and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
DIN 8555 : E 9-UM-200-CKTZ AWS A-5.4 : E 312-16 mod		Hardfacing and repairing Metallurgy (Steelworks) Mining

- Specially designed, universal high-alloy austenitic-ferrite CrNi electrode with embended microelements Mo, V, Co and N, for welding and regeneration of elements made of all types of steel and cast steel (hard-to-weld steels, easy-to-weld steels, high-hardness steels, spring steels, etc.).
- Especially recommended for welding steels of various and unknown composition, such as: unalloyed or alloy structural steels with high-alloy chromium or chromium-nickel steels, for joining or overlaying manganese steels and welding them with other steels.
- Provides very good corrosion and oxidation resistance up to 1000°C.
- Welds steels of unknown composition successfully.
- Thanks to its versatility, it does not require any special skills or technology: works on all AC or DC arc welding machines, does not require surface cleaning, works on grease, rust, moisture, paint, etc.
- The slag rises by itself.
- Works in all positions
- Even inexperienced welders will be able to make a correct weld
- It is necessary to preheat the component to 200ºC or higher when welding special steels such as high alloy tool steels.

Application

Welding and hardfacing

All types of steel and cast steel
Difficult to weld steels,
Construction steels
High hardness steels
Spring steel, manganese
High carbon steel, vanadium spring steel
Stainless steel, tool and die steel
High sulfur steel
Cast steel
Galvanized steel
Vibration resistant steel

Dissimilar (mixed) joints of non-alloy structural steels with high-alloy chromium or chromium-nickel steels, for joining or superstructure of manganese steels and their welding with other steels.

Typical mechanical properties

Tensile strength Rm [N/mm2]	900
Hardness	200 HB after hardfacing / 400 HB after hardening /
Welding current	
Welding positions	

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